



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											

FAULT CATEGORY				
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other	

Work Order ID 117243

\*117243\*

Page 2

April-24-14 10:17:22 AM

Item ID: D350-689-031

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Armrest/Control Guard

Start Date: 4/28/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/28/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00

\*120\*

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-689-013

Location: 04A  
PPP Rev: \_\_\_\_\_

DAS JUN 03 2014  
06  
9-89

①

130

QC21- Final Inspection - Work Order Release

0.00

\*130\*

QC

Memo

0.00

Quality Control

MLJ 14-06-03

MLJ 14-06-03

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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FAULT CATEGORY				
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# Picklist Print

April-24-14 10:17:25 AM

Page 1

Work Order ID: 117243

**\*117243\***

Parent Item: D350-689-031

**\*D350-689-031\***

Parent Item Name: Armrest/Control Guard

Start Date: 4/28/14


Required Date: 4/28/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 12.07.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3021-043		Manufactured	No			101	Each	5.0000	1	1		DAS 33 9-89	
<b>*D3021-043*</b>													
Tube Assembly													

DAS  
31  
9-89

Location

Loc Qty


Loc Code

ST191

5

115420

5

D4666-041		Manufactured	No			101	Each	5.0000	1	1		DAS 33 9-89	
<b>*D4666-041*</b>													
Armrest Assembly													

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST185

3

109716

2

109717


1

ST268A

2

109068

2

D4671-1		Manufactured	No			101	Each	7.0000	1	1		DAS 33 9-89	
<b>*D4671-1*</b>													
Armrest Cushion													

DAS  
31  
9-89

Location

Loc Qty


Loc Code

ST185

7

109722

7

AN4-4A		Purchased	No			101	Each	107.0000	1	1		DAS 33 9-89	
<b>*AN4-4A*</b>													
BOLT													

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST355

107

m120187

2

m125709

105

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

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Page 2

Work Order ID: 117243

**\*117243\***

Parent Item: D350-689-031

**\*D350-689-031\***

Parent Item Name: Armrest/Control Guard

Start Date: 4/28/14

Required Date: 4/28/14

Start Qty: 1.00

Required Qty: 1.00

AN4-10A

Purchased

No

101

Each

65.0000

1 1

**\*AN4-10A\***

Bolt

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST355

65

M127815

65

\*\*

DAS  
33  
9-89

DAS  
06  
9-89

AN4-17A

Purchased

No

101

Each

530.0000

1 1

**\*AN4-17A\***

Bolt

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST357

24

103191

12

124858

12

ST515

506

M127817

256

M128813

250

\*\*

DAS  
33  
9-89

DAS  
06  
9-89

AN970-4

Purchased

No

101

Each

390.0000

1 1

**\*AN970-4\***

Washer

DAS  
31  
9-89

Location

Loc Qty

Loc Code

ST508

390

m126180

140

m127815

250

\*\*

DAS  
33  
9-89

14-05-27

DAS  
06  
9-89

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Shop Packet Print

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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other  _____ _____ _____
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Page 3

Work Order ID: 117243

**\*117243\***

Parent Item: D350-689-031

**\*D350-689-031\***

Parent Item Name: Armrest/Control Guard

Start Date: 4/28/14

Required Date: 4/28/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

101

Each

8,377.000

2 2

**\*MS21042L4\***

Locknut

\*\*

DAS

33

9-89

DAS

06

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST314

56

105054

12

m126015

12

m126275

32

ST509

8310

m127255

71

m127813

1083

m128300

2156

m128798

5000

ST518

11

m127376

11

128300

NAS1149F0432P

Purchased

No

101

Each

2,726.000

4 4

**\*NAS1149F0432P\***

WASHER

\*\*

DAS

33

9-89

DAS

06

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST295

2669

125268

32

M127813

3

M128429

2000

M128591

634

ST510a

57

M126221

57

128429

1405-27

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Operator									
Offset/Setup									
Process									
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Training									
Transport									
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# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. B

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

## PURPOSE:

TO PROVIDE CUSTOMERS WHO HAVE PURCHASED D350-689-011/-021 DUAL HIGH BACK SEAT KITS WITH AN OPTIONAL D350-689-031 ARMREST/CONTROL GUARD KIT.

THE D350-689-031 ARMREST/CONTROL GUARD KIT REPLACES THE D350-689-019 CONTROL GUARD KIT, WHICH WAS FOUND TO BE INEFFECTIVE.

THE D350-689-031 ARMREST/CONTROL GUARD KIT ACTS AS BOTH AN ARMREST AND A GUARD, THAT PREVENTS PASSENGERS FROM SLIDING OFF THE INBOARD SIDE OF THE SEAT INTO THE CONTROLS.

## WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-031 ARMREST/CONTROL GUARD KIT (Seat's Fwd position)	1.4 lb 0.64 kg	-9.0 in -0.23 m	- 12.6 in-lb -0.15 m-kg	60.7 in 1.54 m	85 in-lb 0.99 m-kg
D350-689-031 ARMREST/CONTROL GUARD KIT (Seat's Aft position)	1.4 lb 0.64 kg	-9.0 in -0.23 m	- 12.6 in-lb -0.15 m-kg	64.7 in 1.64 m	91 in-lb 1.05 m-kg

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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED BY: <i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE: 12.07.11 CERT. NO.: SH02-33 ISSUE NO.: 1

B	KIT RENAMED FOR CLARITY	AJS	12.07.11
A	NEW ISSUE	AJS	12.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9619	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMREST/CONTROL GUARD KIT	NTS
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**PARTS LIST:**

QTY -011	QTY -013	QTY -021	QTY -023	QTY -031	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X							D350-689-011	DUAL HIGH BACK SEAT INSTL, LH
1	X						D350-689-013	FLOOR PROVISIONS KIT
		X					D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X				D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
				X			D350-689-031	ARMREST/CONTROL GUARD KIT
1					X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1				X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
				1			D3021-043	TUBE ASSEMBLY
				1			D4666-041	ARMREST ASSEMBLY
				1			D4671-1	ARMREST CUSHION
				1			AN4-4A	BOLT
				1			AN4-10A	BOLT
				1			AN4-17A	BOLT
				1			AN970-4	WASHER
				2			MS21042L4	NUT
				4			NAS1149F0432P	WASHER

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 12.07.11  
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**PROCEDURE:**

- 1) THIS INSTALLATION KIT COMES WITH (1X) D4671-1 ARMREST CUSHION. THIS IS AN UNUPHOLSTERED PIECE OF FOAM TO BE USED TO CUSHION THE SEAT'S OCCUPANT FROM THE ARMREST. IT IS NOT REQUIRED TO BE INSTALLED.

FOR CUSTOMERS WISHING TO INSTALL THE D4671-1 ARMREST CUSHION, IT CAN BE CUT TO THE LENGTH DESIRED BY THE INSTALLER. IT CAN BE UPHOLSTERED WITH FABRIC THAT MEETS THE BURN TEST REQUIREMENTS OF FAR 27.853 (OR FAR 25.853b), PRIOR TO INSTALLATION.

INSTALL THE CUSHION BY SLIPPING IT OVER THE D4666-041 ARMREST ASSEMBLY.

- 2) REMOVE THE D350-689-041/-043 SEAT IN ACCORDANCE WITH ICA-D350-689, SECTION 25.2 / 25.4.
- 3) FOR CUSTOMERS EQUIPPED WITH THE D350-689-019 CONTROL GUARD KIT, REMOVE AND DISCARD THE KIT. PLUG THE HOLE IN THE SEAT BACK STRUCTURE USING THE (1X) AN4-10A BOLT, (2X) NAS1149D0432J WASHERS AND (1X) MS21042L4 NUT PROVIDED IN THE D350-689-031 KIT AS SHOWN IN FIGURE 1.
- 4) REMOVE THE D3021-041 TUBE ASSEMBLY FROM THE SEAT BASE STRUCTURE, BY UNFASTENING THE (6X) MS27039-1-19, (2X) MS27039-1-17 SCREWS, (8X) NAS1149D0332J WASHERS AND (8X) MS21042L3 NUTS AS SHOWN IN FIGURE 2. RETAIN THE HARDWARE IF SERVICEABLE.
- 5) REFERRING TO FIGURE 2: REPLACE THE D3021-041 TUBE ASSEMBLY WITH THE D3021-043 TUBE ASSEMBLY ENSURING THAT THE END WITH THE D4667-041 STUD ASSEMBLY FACES INBOARD. REINSTALL THE (6X) MS27039-1-19, (2X) MS27039-1-17 SCREWS, (8X) NAS1149D0332J WASHERS AND (8X) MS21042L3 NUTS. TORQUE FASTENERS TO 20-25 in-lb (2.3-2.8 Nm).
- 6) REFERRING TO FIGURE 2: INSTALL THE D4666-041 ARMREST ASSEMBLY ONTO THE SEAT BASE USING (1X) AN4-4A BOLT AND (1X) AN970-4 WASHER. INSTALL FINGER TIGHT. DO NOT TORQUE AT THIS TIME.




ROTATE THE D4666-041 ARMREST ASSY UNTIL THE HOLE AT THE AFT END OF THE TUBE ALIGNS WITH THE CENTER LINE OF SEAT BACK TUBULAR STRUCTURE. USING THE HOLE IN THE ARMREST AS A GUIDE DRILL Ø0.257 THRU THE SEAT BACK STRUCTURE.

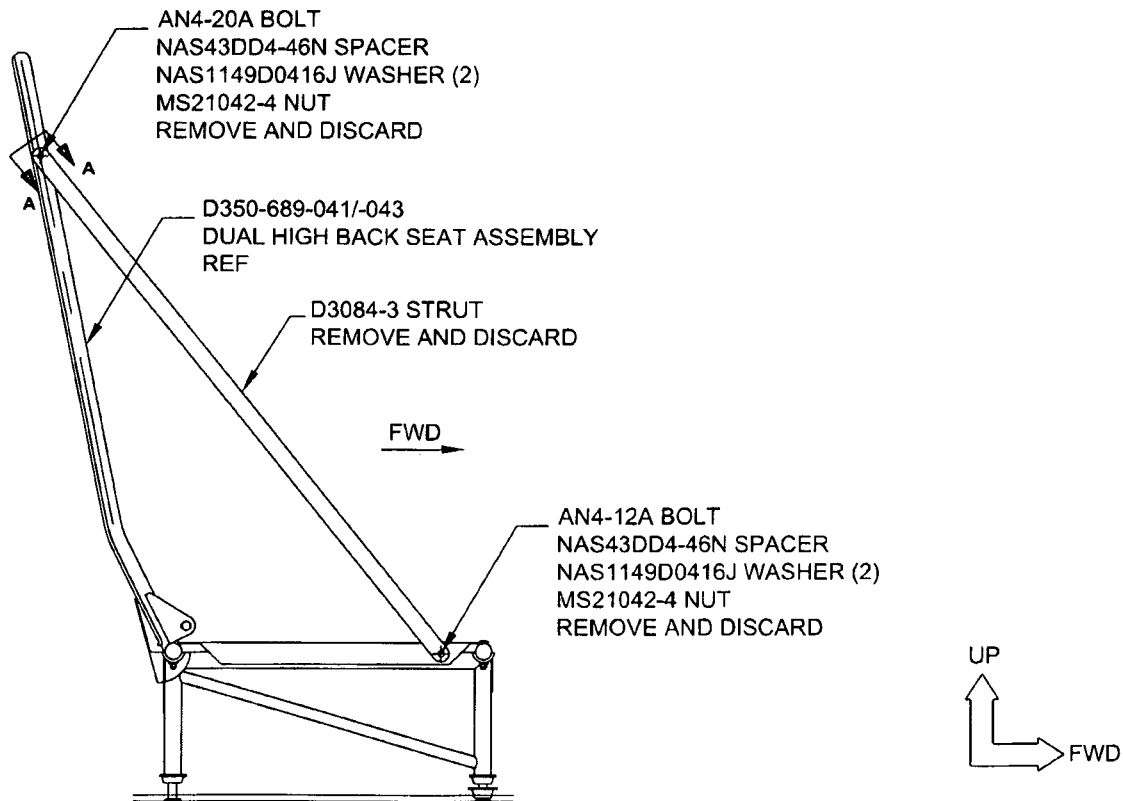
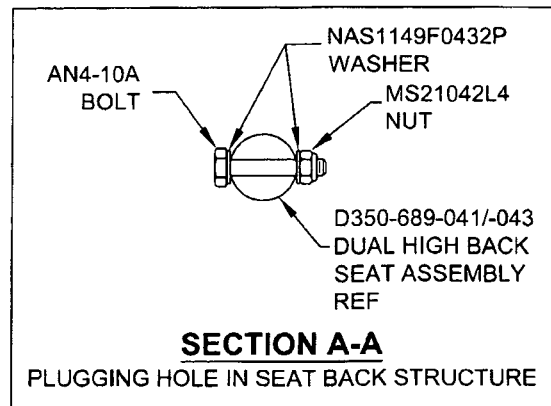
INSTALL (1X) AN4-17A BOLT WITH (2X) NAS1149F0432P WASHER AND (1X) MS21042L4 NUT.

TORQUE AN4 BOLTS TO 50-70 in-lb (5.6-7.9 Nm).

- 7) REINSTALL THE MODIFIED SEAT IN ACCORDANCE WITH ICA-D350-689 SECTION 25.3/25.5.
- 8) UPDATE THE AIRCRAFT LOG BOOK TO INDICATE INSTALLATION OF THE D350-689-031 KIT AND ADJUST WEIGHT AND BALANCE RECORD FOR THE AIRCRAFT WITH THE WEIGHT AND BALANCE DATA PROVIDED IN THIS DOCUMENT.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	12.07.11
CERT. NO.:	SH02-33
ISSUE NO.:	1

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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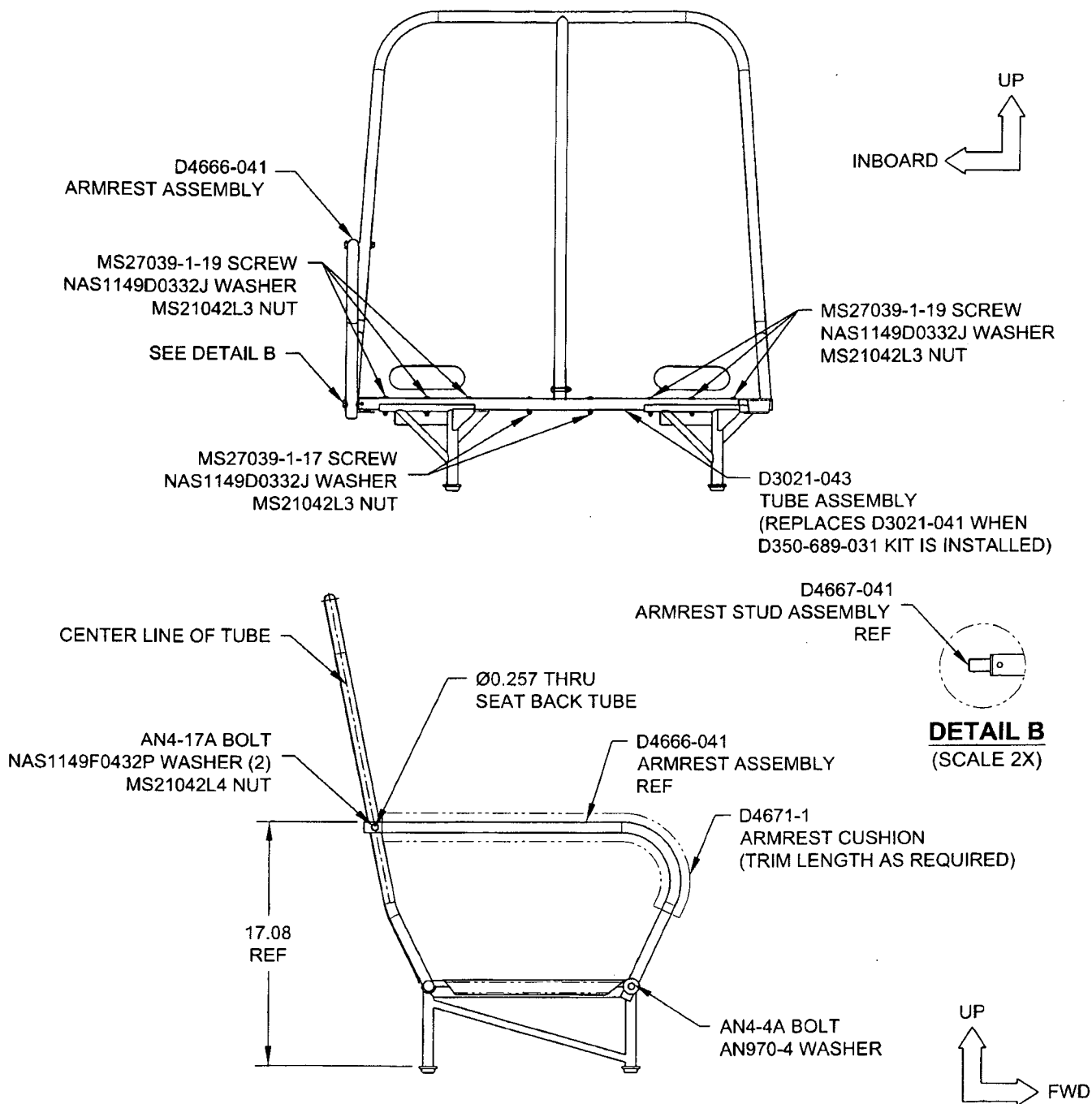


CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

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**FIGURE 2: D350-689-031 ARMREST/CONTROL GUARD KIT**

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# REFERENCE

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9-89

14-05-29

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				1			D4671-1	ARMREST CUSHION
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				2			MS21042L4	NUT
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